

# Work Order ID 77193

November 28, 2011 2:58:43 PM

**\*77193\***

Page 1

Item ID: D3033-144

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Seat Track

Stop **\*NS2\***

Start Date: 11/28/11 Start Qty: 36.00

**\*36\***

Cust Item ID:

Required Date: 12/05/11 Req'd Qty: 36.00

**\*36\***

Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/28

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3033	Rev A1

100	PURCHASING	0.00							
-----	------------	------	--	--	--	--	--	--	--

**\*100\***

Purchasing

Purchasing

Memo

Issue P/O: 15559  
Possible supplier: -Ancra P/N 40456-11-144  
-Brownline P/N 20276-144-0-0  
Description: Medium duty seat track  
All dimensions are in inches  
Tolerances are per Dart QSI 018 unless otherwise noted  
Material release note required

110

Receive & Inspect for Damage & Mat'l Certs 0.00

**\*110\***

Packaging

Packaging

Memo

Ensure Material Release Note is attached

CL 11/29 36.00

11/26 (36)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 77193**

November 28, 2011 2:58:43 PM

**\*77193\***

Page 2

Item ID: D3033-144

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Seat Track

Start Date: 11/28/11 Start Qty: 36.00

**\*36\***

Cust Item ID:

Required Date: 12/05/11 Req'd Qty: 36.00

**\*36\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: **Y89A**

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*73 length @ 12'*  
*236'**11/12/11 (36)**11/12/11**ME*  
*11-12-07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

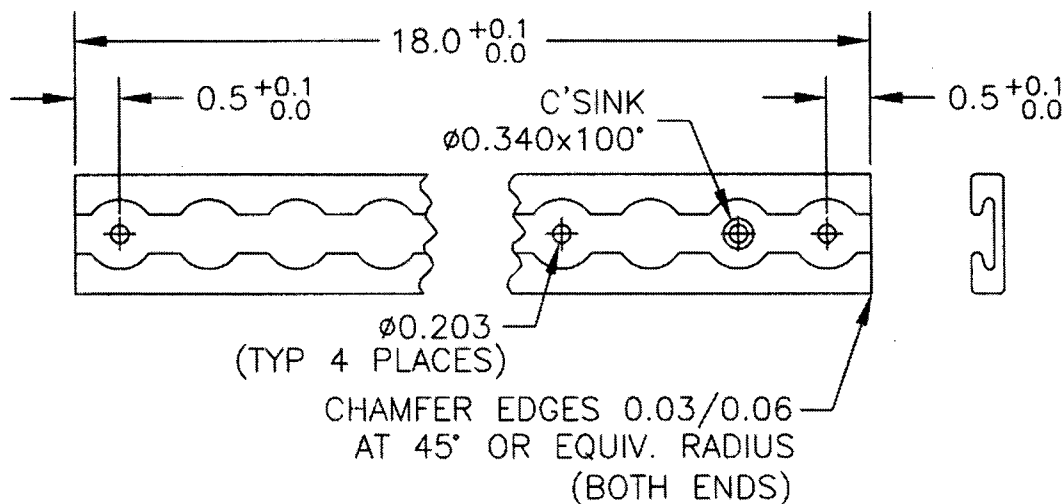
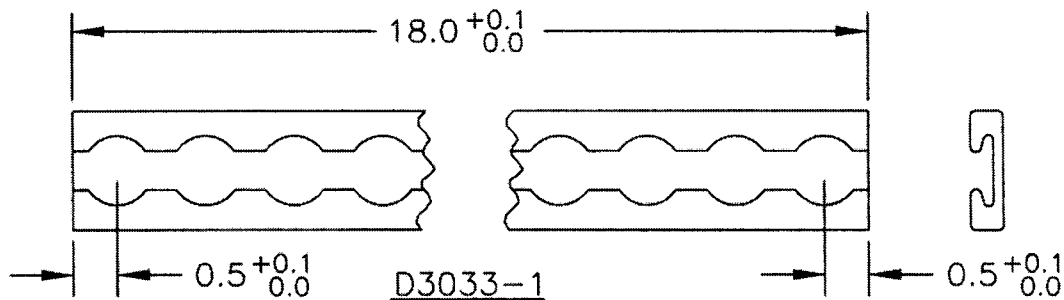
[illegible]

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3033	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE SEAT TRACK	SCALE 1:2
A	01.05.18	NEW ISSUE	
AI	<i>Handwritten initials</i> 03.08.25	NOTE 1 MODIFIED	

## SPECIFICATION CONTROL DRAWING



D3033-3  
(CAN MAKE FROM D3033-1)

*CLU/11/28*

D3033-1 & D3033-3

WID: 77193

1) MAKE FROM: ANCRA, P/N 40456-11-144  
OR BROWNLIN, P/N 20276-144-0-0 } D3033-144

2) DESCRIPTION: MEDIUM DUTY SEAT TRACK

3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
01.05.30 *Handwritten initials*

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO15559**

Purchase Order Date 11/29/11

PO Print Date 11/29/11

Page Number 1 of 1

Order From :  
AVIO-DIEPEN INC.  
PO BOX 536941  
ATLANTA, GA 30353-6941  
US

VU-AVI002

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	770 996 6430	Requisition Nbr	
Vendor Fax	770 996 8430	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	USD
		FOB	Destination-Collect

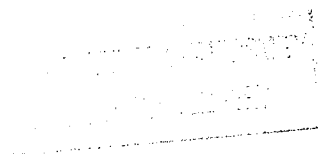
To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

*Chantal Lavoie*

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
40456-11-144		SEAT TRACK	12/07/11 Yes	36.00 Each	FedEx PI collect	\$18.6810	\$672.52

Special Inst: AS PER DWG D3033 REV. A  
B77193  
SUPPLIER P/N: 40456-11-144  
36 FT = 3 LENGTH OF 12 FT

PO Total: \$672.52



No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 11/29/11









**ANCRA**  
INTERNATIONAL LLC

4880 West Rosecrans Avenue  
Hawthorne, California 90250  
Phone: (310) 973-5000 • FAX: (310) 973-1138

Shipping List Number 721165-1

Customer  
Order

30075782

Order  
Date

09-27-11

Page

2

Ship To: 100706  
AVIO-DIEPEN INC.  
561 Airport South Parkway  
Suite#500  
Atlanta, GA 30349

Bill To: 100706  
AVIO-DIEPEN INC.  
561 Airport South Parkway  
Suite#500  
Atlanta, GA 30349

Ship Via: Roadway / Yellow

Contact : RAY HALL

Ship from: W ANCRA WEST HAWTHORNE

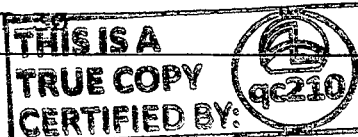
Freight Terms : COL

Ord. Ent By:	Description	Sell Qty	To Stk	Bin	Stock Qty	Shipped
Ln	Item	UM	UM	Loc	To Ship	Qty/UM
CERTIFICATE OF CONFORMANCE						
WE HEREBY CERTIFY THAT THE ABOVE STATED PART NUMBERS REPRESENTED ARE NEW AND HAVE BEEN MANUFACTURED AND INSPECTED IN ACCORDANCE WITH OUR QUALITY ASSURANCE MANUAL, ALL RELEVANT DRAWINGS, SPECIFICATIONS, PURCHASE ORDER REQUIREMENTS, AND LEGIBLY MARKED IN ACCORDANCE WITH FAR 45.15, IF APPLICABLE.						
AS SUCH, THESE PRODUCTS CONFORM TO CURRENT APPLICABLE AIRWORTHINESS REGULATIONS. ALL CHEMICAL, PHYSICAL OR FUNCTIONAL TEST REPORTS RELEVANT TO THE CERTIFICATION OF CONFORMANCE ARE ON FILE IN OUR QUALITY ASSURANCE OFFICE.						
INSPECTOR		DATE				
ROSA CASTILLO		11/12/11				
Shortage Claim Policy						
Ancra customer is responsible for inspecting incoming shipments. Ancra must be notified within fifteen(15) days of receipt of shipment if material is not as ordered, quantity is either surplus or short, or if any damage has occurred in shipment. No claims submitted to Ancra will be accepted after fifteen(15) days of receipt.						

1092 Lbs

Pay  
Terms

NET







# UNIVERSAL ALLOY CORPORATION

180 LAMAR HALEY PKWY CANTON, GA 30114 (770) 479-7230

## EXTRUSION MILL CERTIFICATE OF CONFORMANCE INSPECTION AND TEST REPORT

CUSTOMER ANCRA INTERNATIONAL

PURCHASE ORDER W7979H item 2-2

DATE 03/29/11

ORDER NUMBER 350389

PART NO. 40423-10 rev H

SPECIFICATIONS AMS-QQ-A-200/11 REV. NC

MATERIAL 7075-T6511

### MECHANICAL PROPERTIES

SAMPLE OR LOT	TEST DIRECTION	TEST LOCATION	TENSILE STRENGTH KSI	YIELD STRENGTH KSI	ELONGATION %
C482683	L	Rear	87.86	80.91	11.1

### MANUFACTURED IN THE U.S.A.

CHEMICAL COMPOSITION LIMITS										
ALLOY NOS	SI	FE	CU	MN	MG	CR	ZN	Ti	EACH	OTHERS TOTAL
7075	0.40	0.50	1.2-2.0	0.30	2.1-2.9	0.18-0.28	5.1-6.1	0.20	0.05	0.15

THIS IS TO CERTIFY THAT THE MATERIAL APPLIED TO THE ABOVE ORDER COVERED BY THIS REPORT HAS BEEN INSPECTED IN ACCORDANCE WITH THE SPECIFICATIONS DESCRIBED FORMING A PART OF THIS ORDER AND THAT REPRESENTATIVE MATERIAL HAS BEEN TESTED AND FOUND TO MEET THE APPLICABLE REQUIREMENTS. FURTHER SHOWN ARE THE COMPOSITION LIMITS AND MECHANICAL PROPERTY TEST RESULTS. DOCUMENTATION VERIFYING CONFORMANCE TO THESE REQUIREMENTS IS ON FILE AND SUBJECT TO EXAMINATION.

PERCENT MAXIMUM UNLESS SHOWN OTHERWISE  
REMAINDER ALUMINUM

UNIVERSAL ALLOY CORPORATION

*Victor B. Dangerfield*  
Victor B. Dangerfield - Quality and Metallurgy Manager  
QUALITY ASSURANCE DEPARTMENT



482683T04



4/13/11









# UNIVERSAL ALLOY CORPORATION

180 LAMAR HALEY PKWY CANTON, GA 30114 (770) 479-7230

## EXTRUSION MILL CERTIFICATE OF CONFORMANCE INSPECTION AND TEST REPORT

CUSTOMER ANCRA INTERNATIONAL

PURCHASE ORDER W7979H item 2-2 DATE 03/30/11

ORDER NUMBER 350389 PART NO. 40423-10 rev H

SPECIFICATIONS AMS-QQ-A-200/11 REV. NC MATERIAL 7075-T6511

### MECHANICAL PROPERTIES

SAMPLE OR LOT	TEST DIRECTION	TEST LOCATION	TENSILE STRENGTH KSI	YIELD STRENGTH KSI	ELONGATION %
C482688	L	Rear	88.36	80.91	11.7

### MANUFACTURED IN THE U.S.A.

CHEMICAL COMPOSITION LIMITS										
ALLOY NOS	SI	FE	CU	MN	MG	CR	ZN	TI	EACH	OTHERS TOTAL
7075	0.40	0.50	1.2-2.0	0.30	2.1-2.9	0.18-0.28	5.1-6.1	0.20	0.05	0.15

THIS IS TO CERTIFY THAT THE MATERIAL APPLIED TO THE ABOVE ORDER COVERED BY THIS REPORT HAS BEEN INSPECTED IN ACCORDANCE WITH THE SPECIFICATIONS DESCRIBED FORMING A PART OF THIS ORDER AND THAT REPRESENTATIVE MATERIAL HAS BEEN TESTED AND FOUND TO MEET THE APPLICABLE REQUIREMENTS. FURTHER SHOWN ARE THE COMPOSITION LIMITS AND MECHANICAL PROPERTY TEST RESULTS. DOCUMENTATION VERIFYING CONFORMANCE TO THESE REQUIREMENTS IS ON FILE AND SUBJECT TO EXAMINATION.

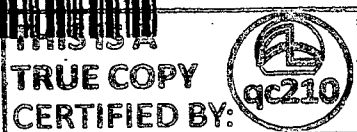
PERCENT MAXIMUM UNLESS SHOWN OTHERWISE  
REMAINDER ALUMINUM

UNIVERSAL ALLOY CORPORATION

*Victor B. Dangerfield*  
Victor B. Dangerfield - Quality and Metallurgy Manager  
QUALITY ASSURANCE DEPARTMENT



482688T04



PAGE 1 of 1





# Universal Alloy Corporation

Invoice Number  
550581

180 Lamar Haley Pkwy  
Canton, GA. 30114-8018  
770.479.7230 - 888.479.7230 - Fax 770.479.7198

Please Remit To:  
P.O. Box 951501  
Dallas, TX 75395-1501

Please Send All Correspondence to: 180 Lamar Haley Pkwy. Canton, GA 30114

Sold To:  
ANCRA INTERNATIONAL  
4880 W. ROSECRANS AVE.

Shipped To:  
ANCRA INTERNATIONAL  
4880 W. ROSECRANS AVE.

HAWTHORNE,, CA 90250

HAWTHORNE,, CA 90250

20/110

Date 4/2/2011	Shipped Via TAY	Shipper No. 350389-1	Date Shipped 4/2/2011	Terms NET 30
Purchase Order Number W7979H (ITEM 2-2)		Part Number 40423-10 Rev H		Die Number 10-7383
QUANTITY	DESCRIPTION		UNIT PRICE	AMOUNT
697.000	ALUMINUM EXTRUSION		32.480/PC	\$22,638.56

NO REJECTED MATERIAL WILL BE ACCEPTED FOR CREDIT OR REPLACEMENT AFTER 30 DAYS FROM DATE OF RECEIPT. UNIVERSAL ALLOY CORP. ACCEPTS VISA, MASTERCARD, AND AMERICAN EXPRESS.

TOTAL  
U.S. Dollars

CUSTOMER COPY

THIS IS A  
TRUE COPY  
CERTIFIED BY:



# UNIVERSAL ALLOY CORPORATION

180 LAMAR HALEY PKWY CANTON, GA 30114 (770) 479-7230

## EXTRUSION MILL CERTIFICATE OF CONFORMANCE INSPECTION AND TEST REPORT

CUSTOMER ANCRA INTERNATIONAL

PURCHASE ORDER W7979H item 2-2

DATE 03/29/11

ORDER NUMBER 350389

PART NO. 40423-10 rev H

SPECIFICATIONS AMS-QQ-A-200/11 REV. NC

MATERIAL 7075-T6511

### MECHANICAL PROPERTIES

SAMPLE OR LOT	TEST DIRECTION	TEST LOCATION	TENSILE STRENGTH KSI	YIELD STRENGTH KSI	ELONGATION %
C482686	L	Rear	87.81	80.30	11.3

### MANUFACTURED IN THE U.S.A.

CHEMICAL COMPOSITION LIMITS											
ALLOY NOS	SI	FE	CU	MN	MG	CR	ZN	TI	EACH	OTHERS	TOTAL
7075	0.40	0.50	1.2-2.0	0.30	2.1-2.9	0.18-0.28	5.1-6.1	0.20	0.05		0.15

THIS IS TO CERTIFY THAT THE MATERIAL APPLIED TO THE ABOVE ORDER COVERED BY THIS REPORT HAS BEEN INSPECTED IN ACCORDANCE WITH THE SPECIFICATIONS DESCRIBED FORMING A PART OF THIS ORDER AND THAT REPRESENTATIVE MATERIAL HAS BEEN TESTED AND FOUND TO MEET THE APPLICABLE REQUIREMENTS. FURTHER SHOWN ARE THE COMPOSITION LIMITS AND MECHANICAL PROPERTY TEST RESULTS. DOCUMENTATION VERIFYING CONFORMANCE TO THESE REQUIREMENTS IS ON FILE AND SUBJECT TO EXAMINATION.

PERCENT MAXIMUM UNLESS SHOWN OTHERWISE  
REMAINDER ALUMINUM

UNIVERSAL ALLOY CORPORATION

*Victor B. Dangerfield*  
Victor B. Dangerfield - Quality and Metallurgy Manager  
QUALITY ASSURANCE DEPARTMENT



482686T04

PAGE 1 of 1



# UNIVERSAL ALLOY CORPORATION

180 LAMAR HALEY PKWY CANTON GA 30114 (770) 479-7230

## EXTRUSION MILL CERTIFICATE OF CONFORMANCE INSPECTION AND TEST REPORT

CUSTOMER ANCRA INTERNATIONAL

PURCHASE ORDER W7979H item 2-2 DATE 03/31/11

ORDER NUMBER 350389 PART NO. 40423-10 rev H

SPECIFICATIONS AMS-QQ-A-200/11 REV. NC MATERIAL 7075-T6511

### MECHANICAL PROPERTIES

SAMPLE OR LOT	TEST DIRECTION	TEST LOCATION	TENSILE STRENGTH KSI	YIELD STRENGTH KSI	ELONGATION %
C482687	L	Rear	87.30	79.34	11.9

### MANUFACTURED IN THE U.S.A.

CHEMICAL COMPOSITION LIMITS										
ALLOY NOS	SI	FE	CU	MN	MG	CR	ZN	Ti	EACH	OTHERS TOTAL
7075	0.40	0.50	1.2-2.0	0.30	2.1-2.9	0.18-0.28	5.1-6.1	0.20	0.05	0.15

THIS IS TO CERTIFY THAT THE MATERIAL APPLIED TO THE ABOVE ORDER COVERED BY THIS REPORT HAS BEEN INSPECTED IN ACCORDANCE WITH THE SPECIFICATIONS DESCRIBED FORMING A PART OF THIS ORDER AND THAT REPRESENTATIVE MATERIAL HAS BEEN TESTED AND FOUND TO MEET THE APPLICABLE REQUIREMENTS. FURTHER SHOWN ARE THE COMPOSITION LIMITS AND MECHANICAL PROPERTY TEST RESULTS. DOCUMENTATION VERIFYING CONFORMANCE TO THESE REQUIREMENTS IS ON FILE AND SUBJECT TO EXAMINATION.

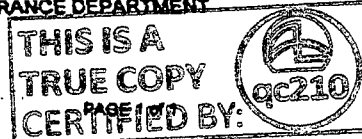
PERCENT MAXIMUM UNLESS SHOWN OTHERWISE  
REMAINDER ALUMINUM

UNIVERSAL ALLOY CORPORATION

*Victor B. Dangerfield*  
Victor B. Dangerfield - Quality and Metallurgy Manager  
QUALITY ASSURANCE DEPARTMENT




482687 T04



**First Article Inspection Report**

 Sheet 1
**Form 3: Characteristic Accountability, Verification and Compatibility Evaluation**

1. Part number <b>82744-10</b>		2. Part name <b>TRAY - LOCK</b>		3. Serial number <b>NA</b>		4. FAI report number <b>82744-10</b>	
				12. Prepared by <b>T.JEMISON</b>		13. Date <b>11/14/2011</b>	
						Stamp	
5. Drawing characteristic number	6. Dwg page number and grid location	7. Key chara. (Y/N)	8. Requirement	9. Actuals		10. Inspection tooling	
			NOTES UNLESS OTHERWISE SPECIFIED:	AS NOTED			
<b>1</b>	SHT1 A-8	N	MAY BE MADE FROM 82001-10 EXTRUSION USING REFERENCE DIMENSIONS SHOWN IN SECTION A - A	VERIFIED		VISUAL	
				VERIFIED		VISUAL	
<b>2</b>	SHT1 A-8	N	MACHINE DIMENSION.	AS NOTED		VISUAL	
<b>3</b>	SHT1 A-8		MACHINE BASIC TRAY PART NUMBER . 156	. 150 X . 008		HT /GAGE	
			HIGH CHARACTERS X .015 MAX APPROX	VERIFIED			
			WHERE SHOWN.	VERIFIED		VISUAL	
			SECTION A - A				
<b>1</b>	SHT3 D-15	N	4 . 031 NOTE 2	3 . 836 OK PER ENGINEERING		CALIPER	
<b>2</b>	SHT3 D-16	N	NOTE 2 . 203	. 204		CALIPER	
<b>3</b>	SHT3 D-16	N	NOTE 2 1 . 700	1 . 702		CALIPER	
			VIEW B				
<b>4</b>	SHT3 D-13	N	Ø . 75	. 75		PIN/GAGE	
<b>5</b>	SHT3 D-13	N	30°	30°		protractor	
<b>6</b>	SHT3 D-13	N	120°	120°		protractor	
<b>7</b>	SHT3 D-12	N	3X Ø . 161 - . 166	. 162		PIN/GAGE	
<b>8</b>	SHT3 D-12	N	CSK' Ø . 292 - . 302 X 100° FAR SIDE	. 295 X 100°		CALIPER	
<b>9</b>	SHT3 D-13	N	Ø 1 . 560	1 . 562		COMP	

THIS IS A  
 TRUE COPY  
 CERTIFIED BY: 

 Form I  
 Rev.:  
 Date:

